

Work Order ID 144078

April 01, 2016 8:11:22 AM

D4840-041
B144078
REV. A

144078

Ship April 5

Page 1

Item ID: D4840-041
Revision ID:
Item Name: Upper Cutter Assembly
Start Date: 4/1/2016 Start Qty: 2.00 *2*
Required Date: 4/4/2016 Req'd Qty: 2.00 *2*
Reference: 5
Accept *N900040100*
Setup Start *NS1*
Stop *NS2*

Approvals: Process Plan: SM Date: 20160401 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run / Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4840	REV A

110	Pick Kit	0.00							
110	Packaging	0.00							
	Packaging								

APR 02 2016

9-89

120		0.00							
120	Small Fab	0.00							
	Small Fab								

Memo
Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M134524

2x

16/04/04
DAS 36 9-89

130	QC5- Inspect part completeness to step on W/O	0.00							
130	QC	0.00							
	Quality Control								

(2)

DAS 38 9-89

APR 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

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Item ID: D4840-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 4/1/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/4/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCF045</u>	0.00							
140									
Packaging	Memo	0.00				2	DAS		
Packaging							6		
							9-89		APR 05 2016
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MF
16-4-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 144078

144078

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4823-1 *D4823-1* Upper Cutter Deflector		Manufactured	No				Each	2.0000		2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck127				2					
				105011				2					
D4824-1 *D4824-1* Upper Cutter Mount		Manufactured	No				Each	6.0000		2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck127				6					
				141294				6					
D4838-2 *D4838-2* Upper Cutter Body, RH		Manufactured	No				Each	7.0000		2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK128				7					
				141316				7					
D4838-1 *D4838-1* Upper Cutter Body, LH		Manufactured	No				Each	1.0000		2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK128				1					
				137371				1					

3

2

2

2

4

142337

Picklist Print

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Work Order ID: 144078

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Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 2.00

Required Qty: 2.00

D4839-1 Manufactured No

Each 27.0000 4

D4839-1

Blade

DAS
6
3-89

Location

Loc Qty

Loc Code

CCK128

27

138971

7

~~141328~~

20

Each

702.0000

28

MS27039-08-19

Purchased No

MS27039-08-19

Screw

DAS
6
3-89

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

339

m132930

84

m133077

22

m134063

233

over006

100

m134294

100

ST277

63

m133769

63

Each

2,925.000

56

NAS1149FN832P

Purchased No

NAS1149FN832P

Washer

DAS
6
3-89

Location

Loc Qty

Loc Code

GA

699

M133316

16

M133769

683

ST260a

1200

M134257

1200

ST262

1026

~~M133709~~

1026

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Shop Packet Print

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• **Picklist Print**

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Work Order ID: 144078

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Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 4/1/2016

Required Date: 4/4/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

Each

1,404.000

28

MS21042L 08

Nut

Location

Loc Qty

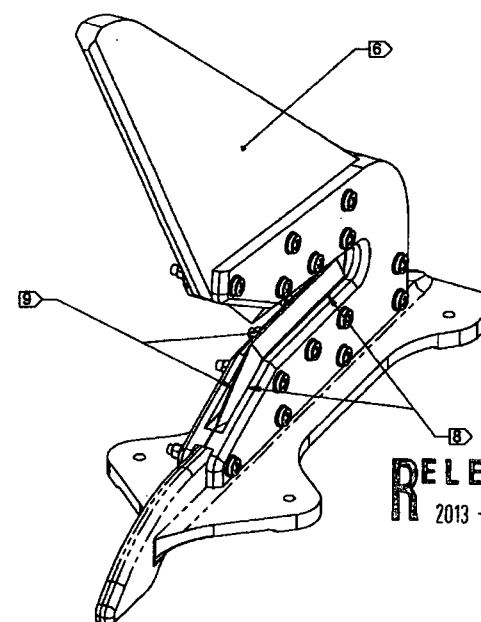
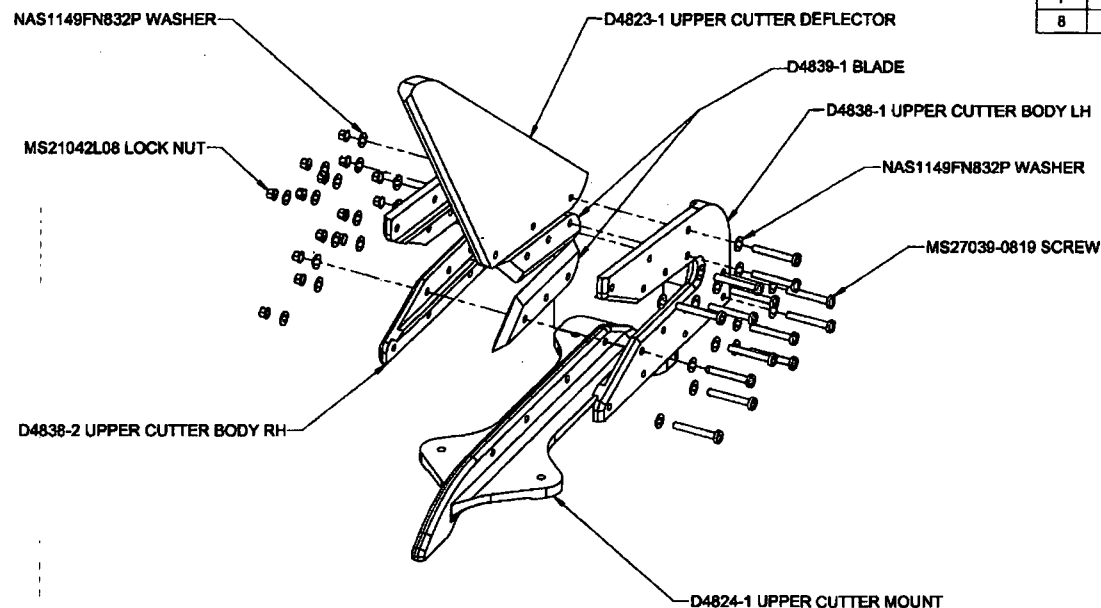
Loc Code

CA	101	
m129682	101	
GA	395	
m133134	3	
m134063	392	
ST303	508	
m133922	308	28
m134574	200	
ST308	400	
m134376	400	

APR 02 2016

D48
6
88

ITEM	QTY	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4838-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN960C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



D4840-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

20160401

SUA
144078

A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	21	D4840	SHEET 1 OF 1
APPROVED	12	TITLE	SCALE
DE APPR.	14	UPPER CUTTER ASSY	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	